Work Ord February-12-14	er ID 113111 8:34:12 AM		*113111*							
Item ID: Revision ID:	D3536-35		Accept	*N900	040	100)* S	Setup Sta	1.71	S1*
Item Name: Start Date:	Gasket Aft 2/10/14 Start Qty: 12.0	. +4.0+		G				Sto	р * М	S2*
Start Date: Required Date:				Cust Item I	ID:					
Reference:		* "17 "		Customer.						
Approvals:	Process Plan: MLJ	Date: 14-02-13	Tooling:	D	ate:		R	Run Sta	"17	R1*
	QC:	Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								******	
D3536	Rev A									
*100 *100* Waterjet FLOW CNC Waterjo	FLOW WATER JET Memo 1-Cut as p Deburr if	per Dwg D3536 Dwg Rev:_ necessary	0.00 0.00 Prog Rev: A	2-			16	0		Jn14-02-20
110	QC2- Inspect parts of	machine FAI/FAIB	0.00							
110 QC Quality Control	Мето		0.00				_16	_0		Jm14-02-20
120	QC8- Inspect parts - s	econd check	0.00 SW 0.00 141212				16			
1 20 oc	Мето		0.00 141212))			10			

Quality Control

DQA:	Date: Date: WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:		Date	:		WORK ORDER NON-	-((JNFOI	RMANCE / UPDATE	W	ork Order up	odate only	AERŌSPACE
Work Orde	or.				DISPOSITION			AGAINS'	T DE	PARTMENT,	/PROCESS	
WOIK Olde	-1				Rework Skid-tube Crosst			Skid-tube Crosstube	be Water Jet Engir			Engineering
Part N	lo				Scrap			Machining Small Fal	\vdash	Pro	d. Eng. Coor.	Quality
NCR No.				Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite					
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data		Ì										
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process				٠,								
Supplier			ŀ									
Training												
Transport				1								
Unapproved						l						
	•					FA	ULT CA	TEGORY		*		
Landi	ng Gear			•	General		/					
	Bend	ing			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Cent	re Not Conc	entric		BOM/Route	Г	Grain	•		Over/Under	tolerance	Set-up
	Cracl	(S			Broken/Damage/Defect		Hardwa	are		Part Incorre	i –	Temperature/Cure
	Crim	p/Kink/Ripp	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crusi	ning			Countersink		4	gned/off center		Positioned V		
	Heat	Treat			Cut Too Short	Г	Mislabe	eled		Power Loss/		Other
	Inspe	ection Strip i	n Tube		Drawing		Misrea	d		•	-	
	Mark	s/Chatter			Drill Holes		Off-set	•				
	Turn	ing Sequenc	e		Finish		Out of	Calibration				
	F-4			Fit/Function		Out of	Sequence		<u>.</u>			

Wai	rk i	Ω rc	ler	ID	11	311	11
YY O	FK '	UIT	ıer	117		JU	11

February-12-14		•		*11 :	₹111 *						Pa	ige 2
Item ID: Revision ID: Item Name:	D3536-35 Gasket Aft		,	Accept	*N900	040	100)* s	etup S	~ .	*NS1 ²	
Start Date: Required Date: Reference:	2/10/14 2/10/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>9</i> * *1 <i>9</i> *		Cust Item I Customer:	D:						
Approvals:	Process Pla	nn:	Date:	Tooling: _ SPC (Y/N):		nte:		R		Ston	*NR1 ³	
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Stoc	k Location \\ \frac{7}{2} \cdot \O(\)	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject Insp. umber Stamp	
120 Packaging		Мето		0.00				_X\(_		<u>t</u>	<u>M (40</u>	<u>1</u> 17(
140		QC21- Final Inspection - V	Vork Order Release	0.00								
140 QC Quality Control		Memo		0.00						##	11-02-21 MF 14	<u>(</u> 1-2-21

DQA:			Date:											
QA Closed:			Date:		•	WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		ork Order up	ndate only	\neg	AEROSPACE
QA Closed.			Date.			·	1				•	,		
Work Orde	er:					DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS		
	•					Rework			Skid-tube Cross	tube		Water Jet		Engineering
Part N	۱o۰					Scrap		1	Machining Small		-	d. Eng. Coor.		Quality
NCR I	NCR No.				Use-as-is Suspected Unapproved		Therr	noforming Finis Large Fab Compo	shing osite	Rec/Stor	re/Packaging Supplier		Other	
Root					Desc	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	1	QC Inspector
Design														
Doc/Data											<u> </u>			
Equip/Tooling														
Handling/Pre														
Material									<i>:</i>					
Operator														
Offset/Setup	_												-	
Process	\vdash			ŀ										
Supplier					İ									
Training	\vdash													
Transport	\vdash					,								
Unapproved				L			EAL	III CA	l Tegory		I			
Landi	nø (Sear				General		OLI CA	ILOOKI					
Land		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain	10614111		Over/Under		—	Set-up
		Cracks				Broken/Damage/Defect	┢	Hardwa	are		Part Incorred		_	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		1	ion Incomplete/Unqualified	ı 📙	Part Lost/Mi		_	Veld
		Cuffs				Contamination		1	tions Incomplete/Unclear		Part Moved	-	_	Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		Positioned V		<u></u>	0
	\vdash	Heat Trea				Cut Too Short		Mislabe	_	F	Power Loss/	- 1	\Box	Other
		Inspectio		Tube		Drawing	-	Misrea		<u> </u>	⊸	~ (
		Marks/Ch				Drill Holes		Off-set						·
		Turning S	equence			Finish		Out of	Calibration		·			
				Fit/Function	Γ	Out of	Sequence							

February-12-14 8:34:17 AM

Work Order ID: 113111

113111

Parent Item:

D3536-35

D3536-35

Parent Item Name: Gasket Aft

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No		100	sf	27.1000	0.6197	8 .26266	7		
MNF060	S 063							**	1	9		Jm14-02-20

NEOPRENE SHEET 0.063

Loc Qty Loc Code Location MAT052 27.1 M126546 27.1

128266

128266

DQA:			Date:			_			_				700	TQ/
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Work Order u	ndata only	<i>^∆E &</i> □	70 S PACE
QA Closed.			Date.	-				1			Work Order u	puate only		
Work Orde	er:					DISPOSITION				AGAINST D	PEPARTMENT	/PROCESS		
	•					Rework			Skid-tube	Crosstube	7	Water Jet	Enginee	ring
Part N	۱o.					Scrap		ļ	Machining	Small Fab	Pro	od. Eng. Coor.	Qua	ality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	01	ther
NCR N	No.					Suspected Unapproved]		Large Fab	Composite		Supplier	_	
Root					Desc	ription of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Descr	ription	Date	Verification	QC Ins	spector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre Material			ļ											
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
							FA	ULT CAT	TEGORY					
Landi		1			_	General	_	٦ ،_		Г	–	Г-	-	
	H	Bending	-+ C		-	Bend BOM/Route	<u> </u>	4	rogram	-	Outside Dim	-	Pressure/F	orced
	\vdash	Centre No Cracks	ot Concer	itric	_	BOM/Route Broken/Damage/Defect	-	Grain Hardwa	·ro	-	Over/Under Part Incorre	<u> -</u>	Set-up Temperatu	
		Crimp/Kir	nk/Rinnle	/Wave	-	Burrs	-	4	ire ion Incomplete/Ur	agualified	Part Lost/M		Weld	re/Cure
		Cuffs	путпрыс	, wave		Contamination	_	4 '	ions Incomplete/U	·	Part Moved	· -	Wrong Sto	ck Pulled
	\vdash	Crushing				Countersink		7	ned/off center		Positioned \	L		on i diled
	_	Heat Trea	at			Cut Too Short	H	Mislabe		-	Power Loss/	_	Other	
		Inspectio	n Strip in	Tube		Drawing		Misread	d	_		- _	.	
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S				Finish		4	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

DART AEROSPACE LTD	Work Order:	113111
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	_		T	Jamo6
19.75	+/-0.030	19.75	-		Т	
17.75	+/-0.030	17.75	_		-	
14.25	+/-0.030	14.25	_		T	
9.50	+/-0.030	9.50	-		T	
4.75	+/-0.030	4.75	_		٧	
2.00	+/-0.030	2.00	_		V	
6.00	+/-0.030	6.00	_		V	
6.75	+/-0.030	Co-75"	-		v	
0.30	+/-0.030	0.30	_		V	
0.30	+/-0.030	0.30	-		ν	
1.89	+/-0.030	1.89			V	
Ø0.19	+0.005/-0.001	0.19			ν	
0.063	+/-0.010	0.060	_		V	
				:		

Measured by:	Jm	Audited by:	→K1	Prototype Approval:	N/A
Date:	14-02-20	Date:	14/2/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.14	New Issue	KJ/JLM A	

26.65 -23.15 21.15 -17.65 -13.40 -- 0.90 - 5.65 1.89 DETAIL A 3.90 #0.19 (TYP 3 PLS) D3536-11 GASKET



113111 MCJ 14-02-13

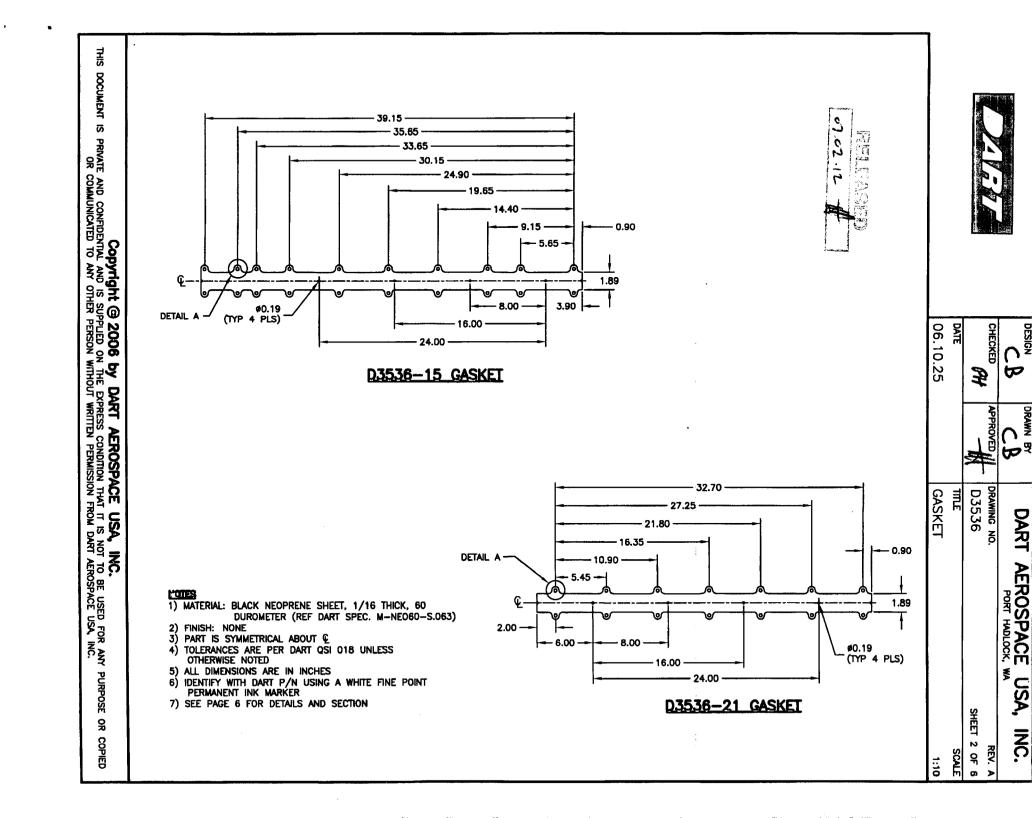


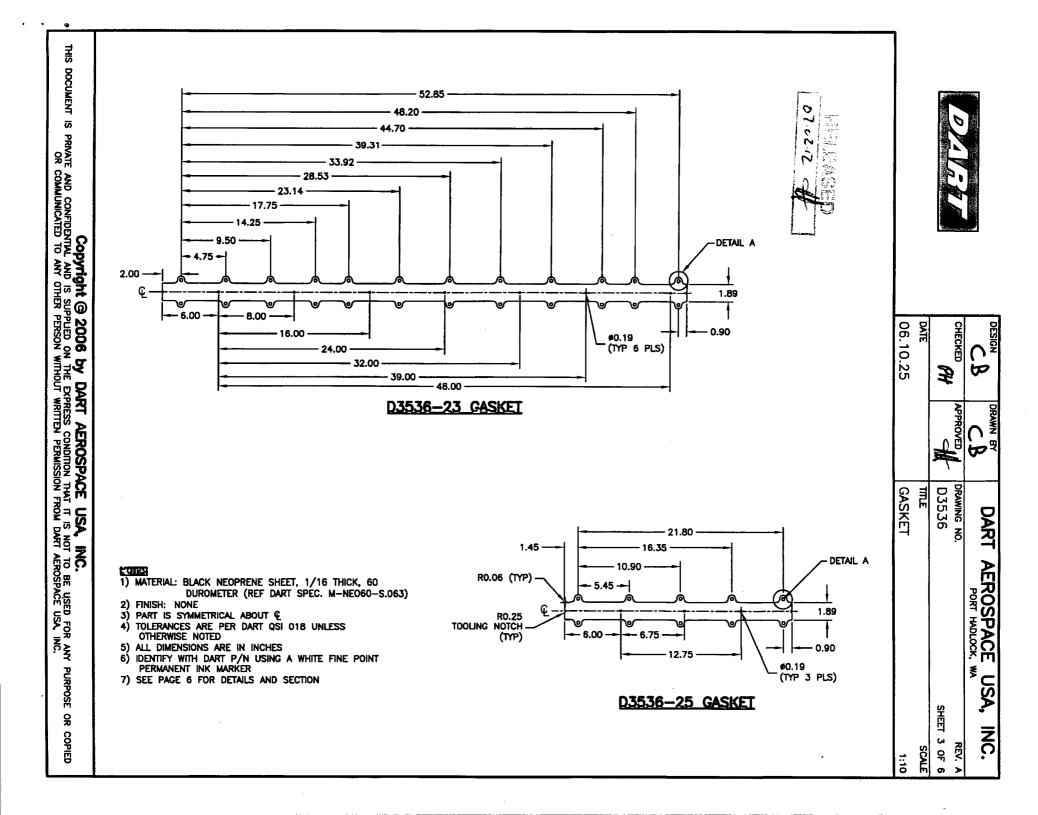
70.00	
32.90	
29.40	
27.40	
23.90	
18.98	
14.07	
9.15	0.90
5.65	,
	4
	1.89
DETAIL A 3.90 3.90	1
14.00	•
(TYP 4 PLS) 20.00 14.00	
D3536-13 GASKET	

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

 CB	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED /	DRAWING NO. REV. A
7.7	#	D3536 SHEET 1 OF 6
DATE		TITLE SCALE
06.10.25		GASKET 1:10
A	06.10.25	06.10.25 NEW ISSUE





06.10.25



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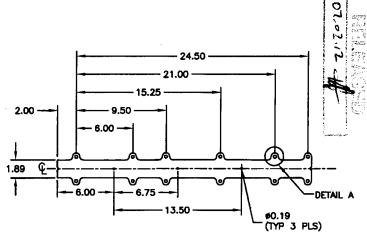
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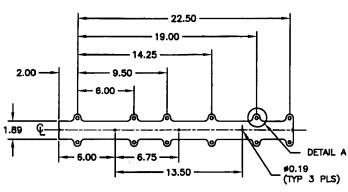
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SCALE 아 6

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D3536-33 GASKET



D3536-31 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE

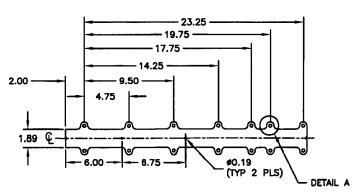
 3) PART IS SYMMETRICAL ABOUT &

 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES

 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

 7) OFE DAGE & COR DETAILS AND SECTION
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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23.25			4	APPROVED J	(
19.75 17.75 1.89 Q 1.89 Q 1.89 Q 1.89 Q 1.89 Q 1.89 Q 1.89 Q 1.89 Q 1.75 DETAIL A	GASKET	TIMLE	D3536	DRAWING NO.	- C
			SHEET		

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IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 07.02.12 27.25 22.50 17.75 2.00 9.50 4.75 1.89 - 6.00 8.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) 06.10.25 D3536-37 GASKET B E 35.71 32.78 - 29.28 DRAWING NO. 25.78 GASKET 23.25 -1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063) 19.75 2) FINISH: NONE 14.25 3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2.00 -9.50 AEROSPACE PORT HADLOCK, ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER 1.88 7) SEE PAGE 6 FOR DETAILS AND SECTION **Ø**0.19 (TYP 3 PLS) **→** 5.00 DETAIL A 9.00 28.00 D3536-39 GASKET SHEET 욹 COPIED G REV. A SCALE 아 6 1:10

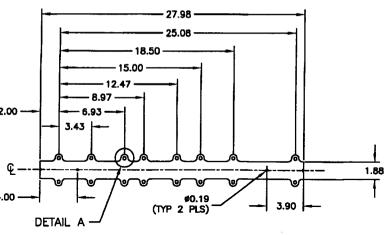
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USA,

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2.00 -3.43 4.00 -DETAIL



D3536-41 GASKET

COTES

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER





CB CB	DRAWN BY	DART	AEROSPACE PORT HADLOCK,
CHECKED	APPROVED *//	DRAWING NO.	
PH?	*	D3536	
DATE		TIMLE .	
06 10 25			

SKET

6 OF 6 **₽**

SCALE 1:10

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